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D3712-042
Job Sheet 190308



Part No: D3712-042

Job Qty: 1 pcs

Part Name: Basket Base Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/7/19

Job Tracking No:

Due Date: 3/13/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3726 REV A, D3727 REV A, D3739 REV.A, D3740 REV A, D3712 REV C, D3735 REV B, D3746 REV B IPP Rev:A new issue 08-01-30 DD verified by:EC IPP Rev:B chg to revB ecn 1145 08-03-19 DD verified by:JLM IPP Rev:C 10.10.21 added pressure wash DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	3/13/19		0.00	16.67	Large Fab - 1		MAR 18 2019 DAS 24 9-89
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
110	Large Fab - Basket - 2 - B4B	1 pcs	3/13/19		0.00	16.67	Large Fab - 1 - B4B		DAS 24 9-89 MAR 18 2019
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
120	QC 5	1 pcs	3/13/19		0.00	0.00	QC 5 - 10		DAS 43 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		

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					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 49	
130 QC 9	1 pcs	3/13/19	0.00	0.00	QC 9 - 10	
					QC 9 - 18	
					QC 9 - 24	DAS
					QC 9 - 43	43
					QC 9 - 50	9-89
					QC 9 - 9	
135 Handfinish - 2-1 Pressure- B4B	1 pcs	3/13/19	0.00	0.31	Handfinish - 2 - 1 - B4B	
					Handfinish - 2 - 2 - B4B	D.R.19/03/19
140 Powdercoat - 2 White Gl(S)- B4B	1 pcs	3/13/19	0.00	0.78	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	B.R.09-03-19
					Powdercoat - 4 - B4B	
150 QC 3	1 pcs	3/13/19	0.00	0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 9	
160 Packaging 1-1 - Pick Kit - B4B	1 pcs	3/13/19	0.00	0.00	Packaging 1 - 1 - B4B	
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 -	

				B4B		
				Packaging 1 - 16 - B4B	BEB 19-03-19	
				Packaging 1 - 17 - B4B		
				Packaging 1 - 18 - B4B		
				Packaging 1 - 19 - B4B		
				Packaging 1 - 20 - B4B		
				Packaging 1 - 21 - B4B		
				Packaging 1 - 22 - B4B		
				Packaging 1 - 23 - B4B		
				Packaging 1 - 24 - B4B		
				Packaging 1 - 25 - B4B		
				Packaging 1 - 26 - B4B		
				Packaging 1 - 27 - B4B		
				Packaging 1 - 28 - B4B		
				Packaging 1 - 29 - B4B		
				Packaging 1 - 30 - B4B		
				Packaging 1 - 31 - B4B		
				Packaging 1 - 32 - B4B		
				Packaging 1 - 33 - B4B		
				Packaging 1 - 34 - B4B		
				Packaging 1 - 35 - B4B		
170	Small Fab - 2 - B4B	1 pcs	3/13/19	0.00 0.87	Small Fab - 1 - B4B	BEB 19-03-19
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
180	QC 5	1 pcs	3/13/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	MAR 19 2019
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				QC 5 - 50		
				QC 5 - 30		
190	Packaging 3-1 - Stock - B4B	1 pcs	3/13/19	0.00	0.00	Packaging 3 - 1 - B4B
						Packaging 3 - 2 - B4B
						Packaging 3 - 3 - B4B
						Packaging 3 - 4 - B4B
						Packaging 3 - 5 - B4B
						Packaging 3 - 6 - B4B
						Packaging 3 - 7 - B4B
						Packaging 3 - 8 - B4B
						Packaging 3 - 9 - B4B
						Packaging 3 - 10 - B4B
						Packaging 3 - 11 - B4B
						Packaging 3 - 12 - B4B
						Packaging 3 - 13 - B4B
						Packaging 3 - 14 - B4B
						Packaging 3 - 15 - B4B
						Packaging 3 - 16 - B4B
						Packaging 3 - 17 - B4B
						Packaging 3 - 18 - B4B
						Packaging 3 - 19 - B4B
						Packaging 3 - 20 - B4B
						Packaging 3 - 21 - B4B
						Packaging 3 - 22 - B4B
						Packaging 3 - 23 - B4B
						Packaging 3 - 24 - B4B
						Packaging 3 - 25 - B4B
						Packaging 3 - 26 - B4B
						Packaging 3 - 27 - B4B
						Packaging 3 - 28 - B4B
						Packaging 3 - 29 - B4B
						Packaging 3 - 30 - B4B
						Packaging 3 - 31 - B4B
						Packaging 3 - 32 - B4B
						Packaging 3 - 33 - B4B
						Packaging 3 - 34 - B4B
						Packaging 3 - 35 - B4B
200	QC 21 - SA	1	3/13/19	0.00	0.00	QC 21 - SA - 21

BEB 19-03-19

DAS
21 MAR 20 2019

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pcs

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: 138840) 1- Take D3166-1 and trim as per dwg D3746 to make D3746-1, Descriptions: D3746-3, D3746-5 and D3746-7 using DT8996 2- Take D3746-3, D3746-5, D3746-7 and drill holes as per dwg D3746 using drill jig DT8995 and DT8996 3- Drill holes in both D3727-1 as per dwg D3727 4- Drill holes in D3735-3 as per dwg D3735 using DT9000 jig 5- Deburr

110 - (Weld per dwg A/R S.S. rod Batch: 138840) 1- cut mesh to fit inside basket base and sides as per dwg D3744 and D3745

120 - (QC5- Inspect part completeness to step on W/O)

130 - (QC9- Inspect visual per QSI004- Fusion Welds)

135 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)

140 - (White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) First coat: START TIME: 9:10 OVEN TEMPERATURE: 375 FINISH TIME: 9:25 ***if necessary*** Second coat: START TIME: _____ OVEN

TEMPERATURE: _____ FINISH TIME: _____

150 - (QC3- Inspect Part Finish)

160 - (Pick Kit)

170 - (Small Fab) Assemble as per dwg D3712

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Identify as per dwg & Stock Location: _____)

200 - (QC21- Final Inspection - Work Order Release)

Job BOM

008611

Part / Item	Component Name	Quantity	Operation	Container
D2327-3	Spacer Bushing	2 pcs (2 ea)	100-Large Fab - Basket - 1	5079118
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5146653
D3166-1	Basket Hoop	5 pcs (5 ea)	100-Large Fab - Basket - 1	5152481
D3725-1	Hoop	2 pcs (2 ea)	100-Large Fab - Basket - 1	5147785
D3748-1	Hinge Half	3 pcs (3 ea)	100-Large Fab - Basket - 1	5155934
D3757-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5155934
D3759-1	Bushing	21 pcs (21 ea)	100-Large Fab - Basket - 1	5157763
M304TS0.750W.065	304 Sq Tube .75X.75X.065W	42.6590 ft (42.659 ea)	100-Large Fab - Basket - 1	5157739
M304EX0.75-16F	Expanded Metal Flat SS	38 sf (38 ea)	110-Large Fab - Basket - 2 - B4B	5147379
AN3-11A	Bolt	6 Ea (6 ea)	170-Small Fab - 2 - B4B	5157480
D2931	Bumper	2 pcs (2 ea)	170-Small Fab - 2 - B4B	586435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	170-Small Fab - 2 - B4B	5076007
MS21042L3	Nut	6 Ea (6 ea)	170-Small Fab - 2 - B4B	5157462-1
NAS1149D0363J	Washer	12 Ea (12 ea)	170-Small Fab - 2 - B4B	5152662
NAS1149DN832J	Washer	2 Ea (2 ea)	170-Small Fab - 2 - B4B	5131200

Small Fab.

Job Allocations

m.u. 008734

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2327-3	2	30	0
	D2581	2	71	0
	D3166-1	5	8	0
	D3725-1	2	4	0
	D3748-1	3	2	0
	D3757-1	2	6	0
	D3759-1	21	161	0
110-Large Fab - Basket - 2 - B4B	M304TS0.750W.065	43	331	0
	M304EX0.75-16F	38	1,934	0
170-Small Fab - 2 - B4B	AN3-11A	6	187	0
	D2931	2	811	0
	MS20600-AD4W3	2	143	0
	MS21042L3	6	2,724	0
	NAS1149D0363J	12	800	0
	NAS1149DN832J	2	1,261	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

95 1/4 long x 46 large basket base
94 1/2 long x 24 1/2 large lid

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AEROSPACE

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Container No: S161832



Part: D3712-042

Job No: 190308

Serial No/Batch: S161832

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/13/19